

Work Order ID 101870

May-16-13 3:54:51 PM

\*101870\*

Page 1

Item ID: D3219-1

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Plate

Start Date: 5/16/13 Start Qty: 60.00

\*60\*

Cust Item ID:

Required Date: 5/24/13 Req'd Qty: 60.00

\*60\*

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 13-05-16

Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D3219	Rev A								
100		0.00							
<b>*100*</b>	FLOW WATER JET					60	0		Jm13-5-27
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3219								
6061, 125	Dwg Rev: <u>A</u>								
	Prog Rev: <u>A</u>								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
<b>*110*</b>						60	0		Jm13-5-27
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
<b>*120*</b>						60			
QC	Memo	0.00							
Quality Control									

BS 27

60  
ca.

# Work Order ID 101870

May-16-13 3:54:51 PM

**\*101870\***

Page 2

Item ID: D3219-1

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Plate

Start Date: 5/16/13 Start Qty: 60.00

**\*60\***

Cust Item ID:

Required Date: 5/24/13 Req'd Qty: 60.00

**\*60\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***  
Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 <b>*130*</b> Small Fab	Small Fab	0.00							
	Memo	0.00							
	1-Deburr if necessary								
140 <b>*140*</b> QC	QC5- Inspect part completeness to step on W/O	0.00							
	Memo	0.00							
150 <b>*150*</b> Packaging	Identify as per dwg & Stock Location: <u>MT.003</u>	0.00							
	Memo	0.00							
	*** STOCK IN STEP CELL***								

N/A

~~13.5.27~~

~~13.5.27~~

~~60~~

60 13.05.29

**Work Order ID 101870**

May-16-13 3:54:51 PM

**\*101870\***

Page 3

Item ID: D3219-1

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Plate

Start Date: 5/16/13 Start Qty: 60.00

**\*60\***

Cust Item ID:

Required Date: 5/24/13 Req'd Qty: 60.00

**\*60\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
<b>*160*</b>									
QC	Memo	0.00							
Quality Control									

13/5/29 *[Signature]*  
MLJ 13-05-29

# Picklist Print

May-16-13 3:54:58 PM

Page 1

Work Order ID: 101870

\*101870\*

Parent Item: D3219-1

\*D3219-1\*

Parent Item Name: Plate

Start Date: 5/16/13

Required Date: 5/24/13

Start Qty: 60.00

Required Qty: 60.00

Comments: IPP A04.04.19New issueKJ/JLM  
ESR B 06.05.25 Waterjet EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.125		Purchased	No			100	sf	187.9862	0.0964	6.088421			
--------------	--	-----------	----	--	--	-----	----	----------	--------	----------	--	--	--

**\*M6061T6S 125\***

6061-T6 .125 Sheet

\*\*

6.1

Jm13-5-27

Location

Loc Qty

Loc Code

MAT021

187.9861578

121473

0.9161578

123279

72.89

125257

114.18

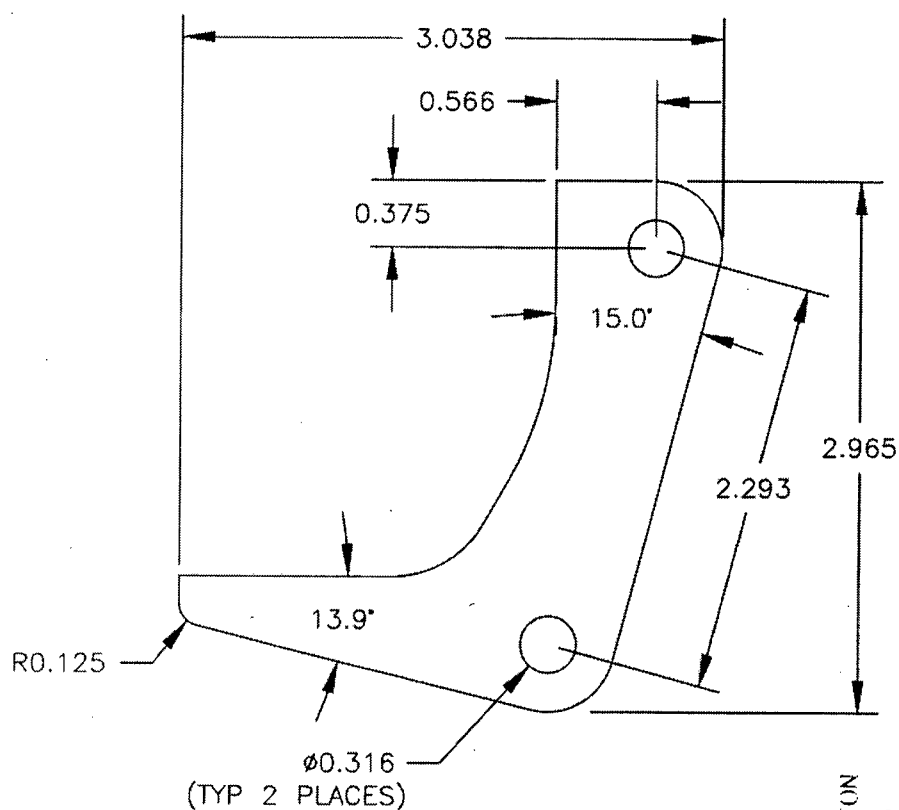
125257





DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3219	REV. A SHEET 1 OF 1
DATE 03.10.10		TITLE PLATE	SCALE 1:1
A	03.10.10	NEW ISSUE	

RELEASED  
04-04-05



**D3219-1 PLATE**

- 1) MACHINE PER DWG FILE "D3219-1.SLDPRT"
- 2) MATERIAL: 6061-T6, 0.125 THICK (QQ-A-250/11)  
(REF DART SPEC M6061T6S.125)
- 3) FINISH: NONE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

NO. 101870-MCS  
13-05-16  
ENCLOSURE  
SUBJECT TO ANY OTHER  
NOTES

Copyright © 2003 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.